

5221766



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D2622-120C
Job Sheet 201139



Part No: D2622-120C

Part Name: Step Extrusion

Job Qty: 120 pcs
105
DAS
61
9-89



Part Weight: 0 lbs

Job Created: 9/25/19

Due Date: 11/8/19

Type: Stock

Note: DWG REV C1

Ship Via:

Status: New

Priority: Medium

Job Tracking No:

Created By: Chantal Lavoie

Description:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard Setup Hrs	Run Hrs	Workcenter/Supplier	Lead Time	Sign-off
100	Purchasing	120		11/8/19	0.00	0.00	Purchasing - 1		DAS
	SEP 25 2019	13					Purchasing - 2		61
		9-89					Purchasing - 3		9-89
110	Packaging 2-1 - Receive - B4B	120		11/8/19	0.00	0.00	Packaging 2 - 1 - B4B		
		pcs					Packaging 2 - 2 - B4B		
							Packaging 2 - 3 - B4B		
							Packaging 2 - 5 - B4B		
							Packaging 2 - 4 - B4B		
							Packaging 2 - 6 - B4B		
							Packaging 2 - 7 - B4B		
							Packaging 2 - 8 - B4B		
							Packaging 2 - 9 - B4B		
							Packaging 2 - 10 - B4B		
							Packaging 2 - 11 - B4B		
							Packaging 2 - 12 - B4B		
							Packaging 2 - 13 - B4B		
							Packaging 2 - 14 - B4B		
							Packaging 2 - 15 - B4B		
							Packaging 2 - 16 - B4B		
							Packaging 2 - 17 - B4B		
							Packaging 2 - 18 - B4B		
							Packaging 2 - 19 - B4B		
							Packaging 2 - 20 -		

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					B4B						
					Packaging 2 - 21 - B4B						
					Packaging 2 - 22 - B4B						
					Packaging 2 - 23 - B4B						
					Packaging 2 - 24 - B4B						
					Packaging 2 - 25 - B4B						
					Packaging 2 - 26 - B4B						
					Packaging 2 - 27 - B4B						
					Packaging 2 - 28 - B4B	DAS 61 9-89					
					Packaging 2 - 29 - B4B						
					Packaging 2 - 30 - B4B						
					Packaging 2 - 31 - B4B						
					Packaging 2 - 32 - B4B						
					Packaging 2 - 33 - B4B						
					Packaging 2 - 34 - B4B						
					Packaging 2 - 35 - B4B						
					Packaging 2 - 36 - B4B						
					120 QC 18	120 pcs	11/8/19	0.00	0.00	QC 18 - 12	
										QC 18 - 14	
										QC 18 - 22	
QC 18 - 25											
QC 18 - 48											
QC 18 - 58											
QC 18 - 61	DAS 61 9-89										
QC 18 - 9											
QC 18 - 81											
130 Packaging 3-1 - Stock - B4B	120 pcs	11/8/19	0.00	0.00						Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B						
					Packaging 3 - 3 - B4B						
					Packaging 3 - 4 - B4B						
					Packaging 3 - 5 - B4B						
					Packaging 3 - 6 - B4B						
					Packaging 3 - 7 - B4B						
					Packaging 3 - 8 - B4B						
					Packaging 3 - 9 - B4B						
					Packaging 3 - 10 - B4B						
					Packaging 3 - 11 - B4B						
					Packaging 3 - 12 - B4B						
					Packaging 3 - 13 - B4B						
					Packaging 3 - 14 - B4B						
					Packaging 3 - 15 - B4B						

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				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	Stu
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
140	QC 21 - SA	120 pcs	11/8/19	0.00 0.00	QC 21 - SA - 21
					QC 21 - SA - 70
					QC 21 - SA - 53

DAS
21
9-39

OCT 1 1 2019

OCT 1 1 2019

Part Op 100 - Purchasing - Issue P/O: _____ a) Extrude as per Dwg D2622 Rev. C f) Order at 120" longg) Bon L
 Descriptions: Canada Inc.

110 - Receive & inspect for Damage & Mat'l Certs - Ensure material certification is attached

120 - QC18 In-Coming Inspection Material - Check Pull test per Dwg D2622 for compliance page attached Check hardness with Webster tester

130 - Identify as per dwg & Stock Location: _____ LOCATION : HALL

140 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2622-120CP	Extrusion	120 pcs (1 ea)	100-Purchasing	5221763

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Purchasing	D2622-120CP	120	0	0

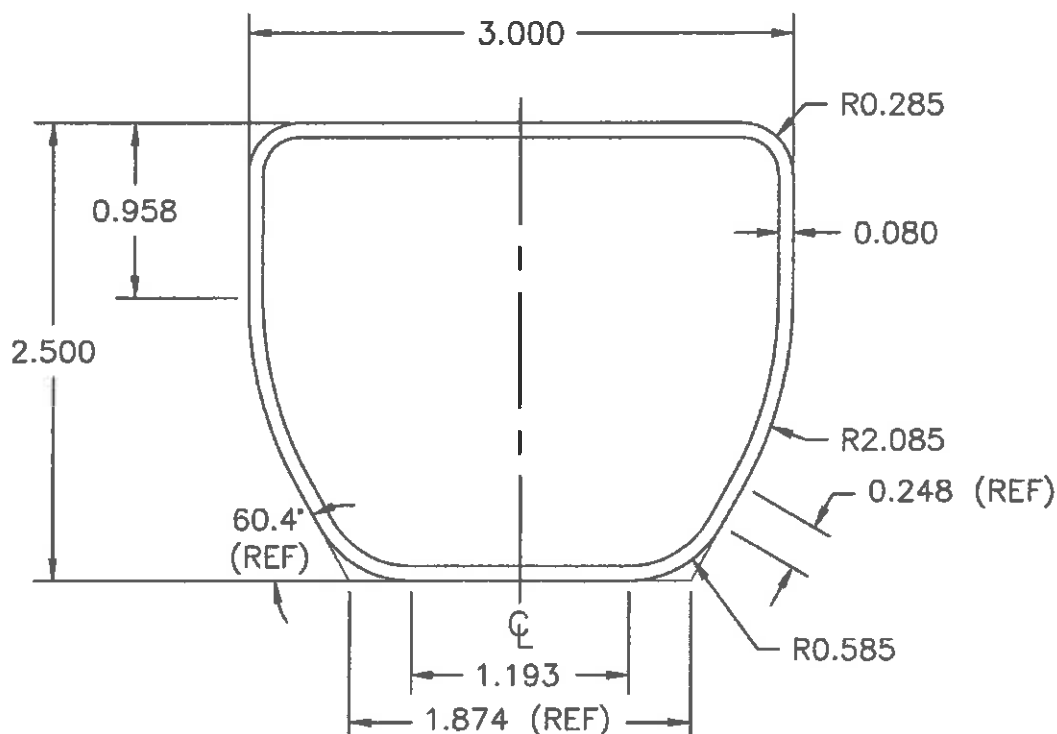
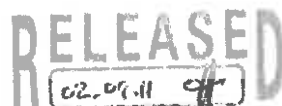
Part Specifications

Specifications could not be found.

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DESIGN KE	DRAWN BY GP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D2622	REV. C SHEET 1 OF 1
DATE 02.09.11		TITLE STEP EXTRUSION	SCALE 1:1
A	96.11.29	NEW ISSUE	
B	97.12.12	CHANGE MATERIAL, ADD TOL. QSI	
C	02.09.11	0.080 WAS 0.085; ADD PART & DIE No.	
CI	02.10.04	ADD 'REV. A' TO DIE NUMBER.	



1) PART NUMBER IS D2622-XXX WHERE 'XXX' IS CUT LENGTH IN INCHES
(EG. D2622-120 IS 120" LONG)

3) MANUFACTURED USING BON-L DIE # 897123 REV. A

4) A SAMPLE FROM EACH BATCH WILL BE PULL TESTED TO ASTM STANDARD B221 BY AN APPROVED TESTING FACILITY TO ENSURE THAT THE BATCH MEETS THE MINIMUM MECHANICAL PROPERTIES STATED BELOW:

MINIMUM TENSILE YIELD STRENGTH = 35 ksi
MINIMUM ULTIMATE TENSILE STRENGTH = 38 ksi
MINIMUM ELONGATION = 8%

6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

7) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

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Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **POHB044598**



Supplier: SIG001-VC
Signature Aluminum Canada Inc.
C/O/ T10322C
PO Box 4488, STN A
TORONTO
ON
M5W 4H1 Canada
Phone: 905-427-6550
Fax: 905-427-2246

PO No: POHB044598
PO Date: 9/25/19
Due Date: 11/7/19
Purchase Order Revision:
Revision Date:
Ship-To Contact: Lavole, Chantal
Phone: 613-623-5200 Ext: 242
Fax: 613-632-1053
clavoie@dartaero.com

SEP 27 2019

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground
Pymt Terms: Net 30
Freight Terms:
Special Comments:

Items

Line Item	Job	Part	Supplier Part No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	201139	D2622-120CP		Extrusion : EXTRUDE AS PER DWG D2622-120 REV. C DIE # DAA- 897123 LENGHT 120" EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF TUBE MATERIAL MUST BE SMOOTH AND FREE FROM DEFECT SCRATCHES,NICKS,DENTS	Firmed	-	11/7/19	120 pcs	0 pcs	120 pcs	\$25.2487/pcs	\$3,029.84
												Grand Total: \$3,029.84

Order Notes

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Procurement Quality Clauses
A005 RIGHT OF ENTRY
A007 FIRST ARTICLE INSPECTION (FAI) BY SELLER, (DOCUMENTATION MAINTAINED BY SUPPLIER)
A012 CHEMICAL AND PHYSICAL TEST REPORTS
A016 PERSONNEL QUALIFICATION
A017 RAW MATERIAL IDENTIFICATION (AS APPLICABLE)
A026 CERTIFICATION OF MATERIAL CONFORMANCE
A041 QUALITY MANAGEMENT SYSTEM
A042 DART NOTIFICATION BY SUPPLIER
A043 RETENTION OF QUALITY DOCUMENT

A048 COUNTERFEIT PARTS AVOIDANCE, DETECTION, MITIGATION AND DISPOSITION PROGRAM
A049 SUPPLIER AWARENESS

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1850 Clements Road, Pickering Ontario, Canada L1W 3R8
Phone: (866) 587-5780 Fax: (905) 427-2207
Visit us at www.signaturealuminum.com

INVOICING AND COMPANY LOCATION
SIGNATURE ALUMINUM CANADA
1850 CLEMENTS ROAD
PICKERING ON L1W 3R8

PACKING LIST

PACKING LIST DATE / DATE DU BODEREAU	10-09-19
PACKING LIST NUMBER / N° DE BODEREAU	045117
SALES ORDER NUMBER / N° DE COM	137894

SHIP TO / EXPÉDIÉ A DART AEROSPACE LTD. 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7 CANADA PHONE: 613-632-5200		SOLD TO / VENDUE A DART AEROSPACE LTD. 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7 CANADA PHONE: 613-632-5200	
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TERMS / FREIGHT	REFER TO THESE NUMBERS ON ALL CORRESPONDANCE
PP	REFEREZ-VOUS A CES NUMEROUX POUR TOUTE CORRESPONDANCE

CUSTOMER ID / ID DU CLIENT	46024	ORDER DATE / DE LA COM	09/30/19	CUSTOMER PO NUMBER / CLIENT PO Nombre	POHB044598	SALES MAN / VENDEUR	042	CREDIT REP / REP DU CREDIT	G.ATTENBOROU	SALES REP / REP. DES VENTES	G.ATTENBOROU
ITEM NO. / NUMÉRO	001	ORIGINAL ORDER QUANTITY / Quantité d'ordre ORIGINAL	1,104 LB	PREVIOUS SHIPPED QUANTITY / PRÉCÉDENT Quantité livrée		TRAILER NUMBER / REMORQUE Nombre	T1525	FIELD SALES REP / REP REGIONAL DES VENTES		CUSTOM SERVICE REP / REP. SERVICE CLIENTELE	
	Y		501 KG			JOB / FICHIER					
			121 PC			CARRIER / TRANSPORTEUR	CANUS				
						BILL OF LADING NUMBER / NO. DE CONNAISSANCEMENT					
						MFG. PART NUMBER / MFG. PARTIE NUMÉRO					
						CUSTOMER PART NUMBER / NUMÉRO DE REFERENCE DU CLIENT					
						ALLOY & TEMPER / ALLIAGE & TEMPER					
						LENGTH / LONGUEUR					
						CUTTING TOLERANCE / Tolérance de coupe					
						FINISH DESCRIPTION / DESCRIPTION DE FINITION					
						FABRICATION DESCRIPTION / DESCRIPTION DE FABRICATION					
						SHIPPING TOLERANCE / EXPÉDITION TOLERANCE					
						NBR OF PKGS / NBR DE PKGS					
						GROSS LBS / LIVRES BRUT					
						NET QUANTITY / QUANTITÉ NETTE					
						UNIT / UNITÉ					
						QUANTITY DUE / Quantité en raison					

001	1,104 LB	501 KG	121 PC	6061 T6	120.0000 IN	2	979	926 LB	49 PC
Y				D2622-120CP	Cut (+): 0.1180	444	444	420 KG	56 PC
					Cut (-): 0.0000	105	105	105 PC	



Transportation/Traffic damages and/or shortage claims are to be noted on the delivery copy of sellers shipping packing lists and signed and dated below by customers authorized representatives. No return materials will be accepted for credit without permission. The articles and/or services covered by this shipping packing list were produced in accordance with the fair labor standards act of 1938 as amended. Order accepted subject to the terms and conditions stated on our website.

2	979	926 LB
	444	420 KG
	105	105 PC
TOTALS		

ACKNOWLEDGEMENT OF GOODS DELIVERED AND CONDITION

DATE OF DELIVERY

DRIVER

SIGNATURE ALUMINUM CANADA

1850 CLEMENTS RD
PICKERING, ON L1W 3R8

CERTIFICATE OF COMPLIANCE

Cert Date	Cert No	Sales Order	Page
10/05/2019	5551432	137894	1
Cust PO	Btl. No	Lot	Date
POHB044598	045117	927696	10/09/19

Sold To

46024
DART AEROSPACE LTD.
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7
CANADA

Ship To

46024
DART AEROSPACE LTD.
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7
CANADA

Item No	Part No	Item Description	Cust Part
001	DAA-897123-2	10FT MILL 6061 T6	D2622-120CP
Gross Weight	979 LBS		
Net Qty	926 LBS 105 PCS 2 PKGS		
Specification	AMS-QQ-A-200/8 & ASTM B221-08		
	Die Desc		

Mechanical Tests:

<u>Tensile</u>	<u>Yield</u>			
<u>MPA / KSI</u>	<u>MPA / KSI</u>	<u>% Elongation</u>	<u>Conductivity</u>	<u>HRE</u>
284.2 / 41.2	248.3 / 36.0	12.0	N/A	90

Chemical Analysis:

<u>Si</u>	<u>Fe</u>	<u>Cu</u>	<u>Mn</u>	<u>Mg</u>	<u>Cr</u>	<u>Zn</u>	<u>Ti</u>	<u>V</u>	<u>Zr</u>
0.58	0.30	0.21	0.05	0.87	0.06	0.09	0.02	0.01	0.00

This Material is Made in Canada
This Material is RoHS Compliant

This will certify that the material described herein has been inspected and tested in accordance with Signature Aluminum Canada's standard sampling and testing procedures or in accordance with the requirements of any specification forming a part of the material description to the extent indicated herein. Data of chemical composition for the material and test results from samples representative of the material are set forth above hereof or in any attachments hereto. This information shows that the material meets the applicable requirements. Inspection and test records are maintained on file. This certificate shall be deemed apart of and subject to the terms and conditions of warranty set forth on the reverse side of our order acknowledgement form. No other warranties are applicable.

S. Gooder
Quality Manager
Signature Aluminum Canada Inc

ISO 9001/TS16949 Registered Company

Visit us at www.signaturealum.com

MATERIAL RECEIPT INSPECTION FORM

MATERIAL: D2622-120C
 DATE: 14/10/10

PO / BATCH NO.: PO48044598/5201766

MATERIAL CERT REC'D: Yes
 QUANTITY RECEIVED: 105x
 QUANTITY INSPECTED: 105x
 QUANTITY REJECTED: _____

THICKNESS ORDERED: 0.080"
 THICKNESS RECEIVED: 0.080"
 SHEET SIZE ORDERED: _____
 SHEET SIZE RECEIVED: _____

DESCRIPTION	NCR (Check Y/N)		COMMENTS
SURFACE DAMAGE	Y	N	
CORRECT FINISH	Y	N	
CORROSION	Y	N	
CORRECT GRAIN DIRECTION	Y	N	
CORRECT MATERIAL PER M-DRAWING	Y	N	
CORRECT THICKNESS	Y	N	
PHOTO REQUIRED	Y	N	
CORRECT REF # TO LINK CERT	Y	N	
CORRECT MATERIAL IDENTIFICATION	Y	N	
CORRECT M# ON THE MATERIAL	Y	N	
DOES THIS MATERIAL REQUIRE ENGINEERING SIGN OFF	Y	N	
DOES THIS REQUIRE AN EXTRUSION REPORT	Y	N	

CUT SAMPLE PIECE OF MATERIAL AND PREFORM A HARDNESS CHECK. RECORD RESULTS BELOW					
	HRC	HRB	DUR A	DUR D	WEBSTER
TYPE OF MATERIAL					
SIZE OF TEST SAMPLE					
HARDNESS / DUROMETER READING					

testers located in the Quality Office

QC 18 INSPECTION	ENGINEERING SIGNOFF (if required)
INSPECTED BY: _____	SIGNED OFF BY: _____
DATE: _____	DATE: _____

Attach this inspection sheet with the corresponding material cert and remit to be scanned and received in